



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2570

Job Sheet 168653



Part No: D2570

Job Qty: 400 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/21/17

Job Tracking No:

Due Date: 11/28/17

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP E 02.08.29 Re-format; Removed finishing; Material change KJ IPP F 07.07.06 rev B dwg EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	400 Ea		11/27/17	0.00	0.00	Start Up Machining		
100	Hardinge	400 pcs		11/28/17	0.01	15.38	Hardinge		
110	QC	400 pcs		11/28/17	0.00	0.00	QC2		
120	QC	400 pcs		11/28/17	0.00	0.00	QC8		
130	Packaging	400 pcs		11/28/17	0.00	0.00	Packaging3		
140	QC21-SA	400 Ea		11/28/17	0.00	0.00	QC21		

Part Op 100 - Machine as per folio FA258
Descriptions: 130 - LOCATION : ST008

DAS
21
9-59

JAN 12 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R0.750	31	62	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.800inches ± 0.010	0.810 0.790		
2	Bushing	0.060inches ± 0.005	0.065 0.055		
3	Bushing	0.010inches + 0.010 - 0.000	0.020 0.010		
4	Bushing	0.425inches + 0.000 - 0.002	0.425 0.423		
5	Bushing	0.257inches + 0.006 - 0.001	0.263 0.256		
6	Bushing	0.750inches ± 0.010	0.760 0.740		
7	Bushing	0.030inches ± 0.010	0.040 0.020		
8	Bushing	20.000Degrees ± 0.000	20.000 20.000		

M303R0.750
S021850

74 7/8" + 74 3/8" Plex 11/21/17 7:31 AM dart.lacelle.linda

+ 74" 18.6

148" 5007170

12

DART
AEROSPACE
S030004

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Bushing

PART NO: D2570

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 01/08/18

Job No: 168653

DART AEROSPACE LTD		Work Order:	168653
Description: Bushing		Part Number:	D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	.800	✓		Vern LPO	
0.060	+/-0.005	.061			↓	
R0.010	+0.010/-0.000	.01			↓	
Ø0.425	+0.000/-0.002	.424			Mic LPO	
Ø0.257	+0.006/-0.001	.259			Vern LPO	
Ø0.750	+/-0.010	.745			↓	
0.030 x 20°	+/-0.010	.03 x 20°			↓	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 18-01-08	Date: 18/01/08	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
C	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	
D	08.07.23	Tolerance for Ø0.257 revised	KJ/DD	<i>[Signature]</i>

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D2570 Revision: Bushing														
140	QC21-SA	S030004	168653	400 Ea	0	S030004	ST008	Bin	Stock	1/8/2018	Issue Container			
Operation Totals:		1		400	0									
Part Totals:		1		400	0									
Part Number: M303R0.750 Revision: 303 Round Bar 0.750														
100	Receive Ft	S021850	168653	8 ft	0		MAT028		Stock	12/14/2017	*			
		S030001	168653	4 ft	0		Start Up Machining	Box	Stock	1/8/2018	Issue Container			
Operation Totals:		2		12	0									
Part Totals:		2		12	0									
Totals:		3		412	0									